

Work Order ID 77304

December-02-11 9:57:33 AM

77304

Page 1

Item ID: DSK081 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2940-1 TURNING DETAIL
 Start Date: 02/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 16/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK081	Rev <u>B</u> A								
100	MORI SEIKI CNC LATHE LARGE	0.00				10	0		
100									
Doosan	Memo	0.00							
Doosan Lathe	Turn blank as per Folio FA079	SL 11/12/16							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				10	0		
110									
QC	Memo	0.00							
Quality Control		SL 11/12/16							
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control		SL 11-12-21							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: MAT060		SL	11-12-21					
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten signatures and dates:
 11-12-21
 11-12-21

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

December-02-11 9:57:38 AM

Work Order ID: 77304

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Parent Item: DSK081

DSK081

Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 02/12/2011

Required Date: 16/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-007

Manufactured

No

Each

4.0000

10

D6104-007

**

Round Billet, 17-4

52 11/2/11

Location

Loc Qty

Loc Code

MAT043

2

73504

2

MAT046

2

71182

2

76833

2
11
12
16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 77304
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.956	4.956	4.956	4.956	4.956
C	0.718	0.738		.726	.726	.726	.726	.726
D	0.090	0.110		.102	.102	.102	.102	.102
E	3.564	3.584		3.574	3.574	3.573	3.573	3.573
F	0.022	0.042		.031	.031	.031	.031	.031
G	3.444	3.464		3.453	3.453	3.454	3.453	3.453
H	0.112	0.132		.115	.118	.118	.118	.118
I	2.170	2.190		2.182	2.182	2.185	2.182	2.182
J	4.451	4.471		4.466	4.466	4.461	4.460	4.461
K	0.413	0.433		.423	.423	.423	.423	.423
L	0.913	0.933		.925	.925	.925	.925	.925
M								
N								
O								
P								

Measured by: SA **Date:** 11/2/17

Audited by: JL **Date:** 11-2-21

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77304
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

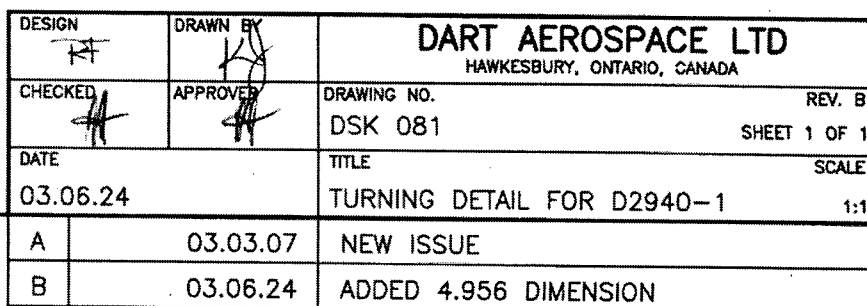
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

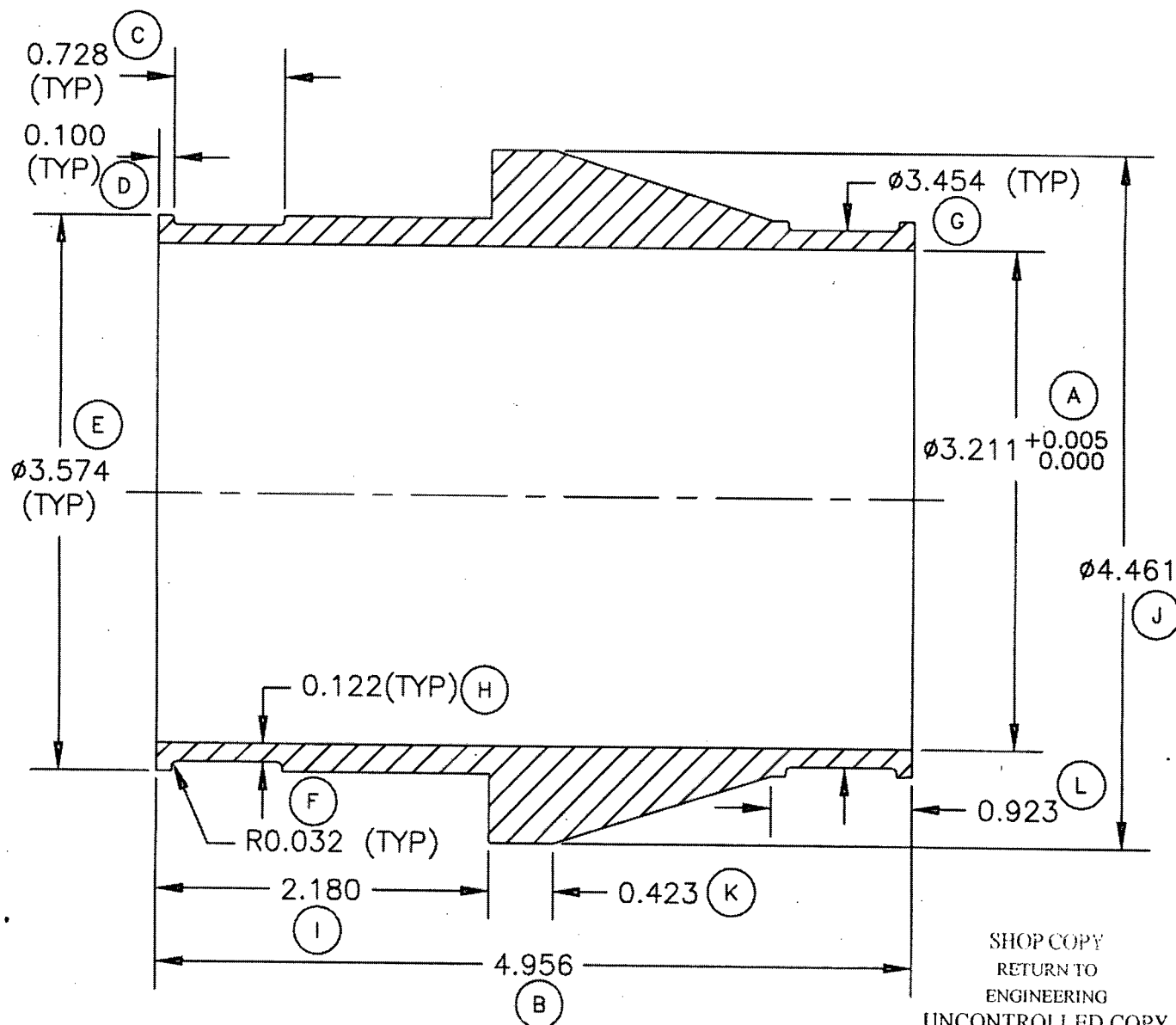
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.957	4.957	4.957	4.957	4.957
C	0.718	0.738		.726	.726	.726	.726	.726
D	0.090	0.110		.107	.102	.102	.102	.102
E	3.564	3.584		3.573	3.573	3.573	3.574	3.573
F	0.022	0.042		.031	.031	.031	.031	.031
G	3.444	3.464		3.453	3.453	3.453	3.454	3.453
H	0.112	0.132		.118	.118	.117	.118	.118
I	2.170	2.190		2.182	2.182	2.180	2.181	2.182
J	4.451	4.471		4.460	4.460	4.461	4.460	4.460
K	0.413	0.433		.425	.425	.425	.425	.425
L	0.913	0.933		.925	.926	.926	.926	.926
M								
N								
O								
P								

Measured by: SA	Date: 11/12/16
Audited by: JL	Date: 11-12-21
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



RELEASED
03-07-01



D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77304

NO. 77304

M.L.J

11/12/02

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